



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D4893-2

Job Sheet 177137



Part No: D4893-2

Job Qty: 4 ea

Part Name: Hard Point Adapter, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/7/18

Job Tracking No:

Created By: Linda Lacelle

Description:

Due Date: 6/8/18

Type: SOLD

Note: DWG REV A IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Machining-3		DAS
100	Bandsaw	4 pcs	6/8/18	6/8/18	0.00	0.00	Bandsaw1		54
110	CNC Vertical Machining	4 pcs	6/8/18	6/8/18	3.09	4.88	HAAS1-5		9-89
130	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC8 Machining-3		SA 18-06-10
140	HandFinish	4 pcs	6/8/18	6/8/18	0.00	0.27	HandFinish1		SA 18-6-7
150	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC7-4		SA 18-6-7
151	Powdercoat	4 pcs	6/8/18	6/8/18	0.00	0.14	Powdercoat1		SA 18-6-7
155	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC3		SA 18-6-7
170	Packaging	4 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-2		JUN 07 2018
180	QC21-SA	4 Ea	6/8/18	6/8/18	0.00	0.00	QC21		JUN 08 2018

Part Op 100 - Cut blank:3.375" long

Descriptions: 110 - 1- Machine as per Folio FB193 and Dwg D4893

151 - MASK AS PER NOTE 9

M/134839 START: 8:50 CUT: 3:20 FINISH: 9:20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X05.000	6061T6 Bar 2.00 X 5.000	1.1600 ft (.29 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X05.000	1	12	0



Container No: S078301



Part: D4893-2

Job No: 177137

Serial No/Batch: S078301

Revision:

Inspector:

Exp Date: 06/05/2018

Instructions:

Dart Aerospace Ltd.
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Date: 06/05/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hardpoint Adaptr, RH	72.000Degrees ± 0.500	72.500 71.500	Angle	
2	Hardpoint Adaptr, RH	1.500Inches ± 0.030	1.530 1.470		
3	Hardpoint Adaptr, RH	0.030Inches ± 0.030	0.060 0.000		
4	Hardpoint Adaptr, RH	45.000Degrees ± 0.500	45.500 44.500	Angle	
5	Hardpoint Adaptr, RH	2.450Inches ± 0.030	2.480 2.420		
6	Hardpoint Adaptr, RH	1.300Inches ± 0.030	1.330 1.270		
7	Hardpoint Adaptr, RH	0.750Inches ± 0.030	0.780 0.720		
8	Hardpoint Adaptr, RH	2.500Inches ± 0.005	2.505 2.495		
9	Hardpoint Adaptr, RH	1.250Inches ± 0.005	1.255 1.245		
10	Hardpoint Adaptr, RH	0.250Inches ± 0.030	0.280 0.220	Radius	
11	Hardpoint Adaptr, RH	0.500Inches ± 0.030	0.530 0.470		
12	Hardpoint Adaptr, RH	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
13	Hardpoint Adaptr, RH	0.204Inches + 0.005 - 0.001	0.209 0.203	Diameter	
14	Hardpoint Adaptr, RH	1.500Inches ± 0.030	1.530 1.470		
15	Hardpoint Adaptr, RH	1.000Inches ± 0.030	1.030 0.970		
16	Hardpoint Adaptr, RH	1.000Inches ± 0.030	1.030 0.970		
17	Hardpoint Adaptr, RH	0.130Inches ± 0.030	0.160 0.100	Radius	
18	Hardpoint Adaptr, RH	0.830Inches ± 0.030	0.860 0.800		
19	Hardpoint Adaptr, RH	0.100Inches ± 0.030	0.130 0.070		
20	Hardpoint Adaptr, RH	45.000Degrees ± 0.500	45.500 44.500	Angle	
21	Hardpoint Adaptr, RH	1.750Inches ± 0.030	1.780 1.720		
22	Hardpoint Adaptr, RH	1.460Inches ± 0.030	1.490 1.430		
23	Hardpoint Adaptr, RH	1.650Inches ± 0.030	1.680 1.620		
24	Hardpoint Adaptr, RH	4.000Inches ± 0.030	4.030 3.970		
25	Hardpoint Adaptr, RH	0.250Inches ± 0.030	0.280 0.220		
26	Hardpoint Adaptr, RH	45.000Degrees ± 0.500	45.500 44.500	Angle	
27	Hardpoint Adaptr, RH	0.750Inches ± 0.010	0.760 0.740		
28	Hardpoint Adaptr, RH	1.015Inches ± 0.010	1.025 1.005	Diameter	

